

Work Order ID 153031

Thursday, January 05, 2017 8:41:09 AM

153031

Page 1

Item ID: D4034-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib
Start Date: 11/3/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: DAS Date: JAN 05 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	C								
100		0.00							
100									
Large Fab	Memo	0.66							
Large Fab	1- Cut tube as per dwg D4034 2- Drill and chamfer holes as per dwg use <u>DT9715</u>								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>WA004</u>	0.00							
120									
Packaging	Memo	0.02							
Packaging	LOCATION: WA004								

12 DG 2017/01/0912 17.01.09 CPC12 DG 2017/01/09

Work Order ID 153031***153031***

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Item ID: D4034-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib

Start Date: 11/3/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
Qty **DAS**
21
9-89Reject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.20

Quality Control

JAN 10 2017



JAN 09 2017

Picklist Print

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Page 1

Work Order ID: 153031

153031

Parent Item: D4034-3

D4034-3

Parent Item Name: Rib

Start Date: 11/3/2016

Required Date: 11/7/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC IPP Rev:D 11.01.19 AS PER DWG
REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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~~M304TS0.750W.049~~

Purchased

No

100

f

1,201.482

1.4375

18.15789

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

De 2017/01/09

Location

Loc Qty

Loc Code

WA004

1201.482

B135996

19

M134940

38

M135226

8.461

M135711

65

M135899

293.021

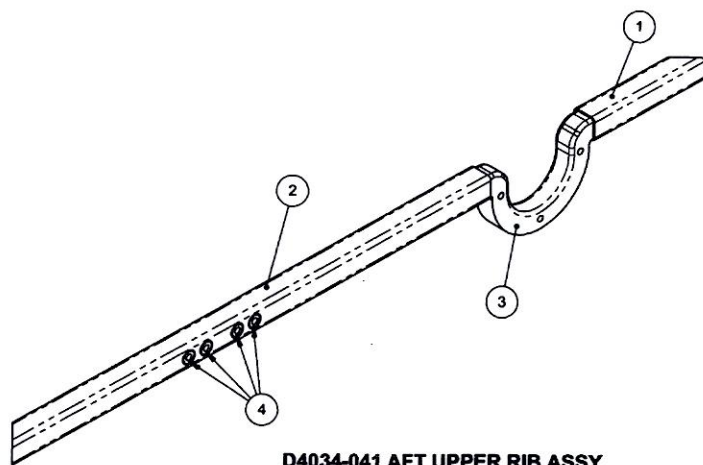
~~M135996~~

197

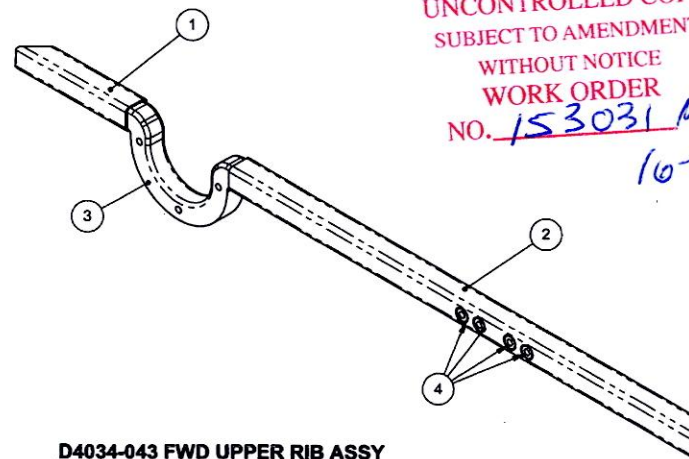
M136378

600

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY

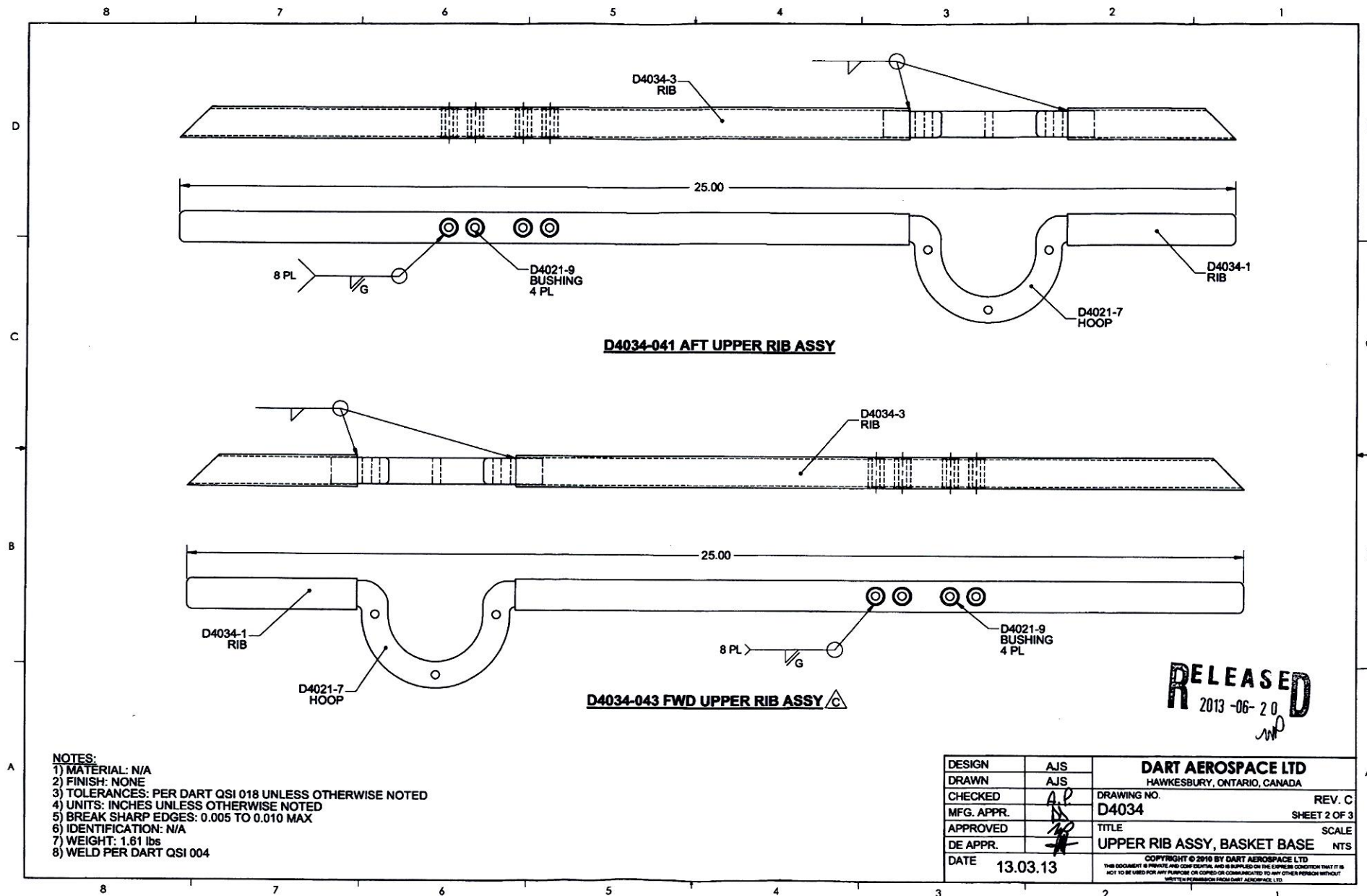


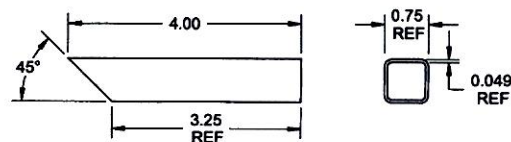
D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153031 MJS
10-11-09

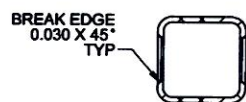
RELEASED
2013-06-20
AM

C	-043 REDESIGNED AS MIRROR IMAGE OF -041 -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.	AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	IS	D4034	SHEET 1 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	UPPER RIB ASSY, BASKET BASE	NTS
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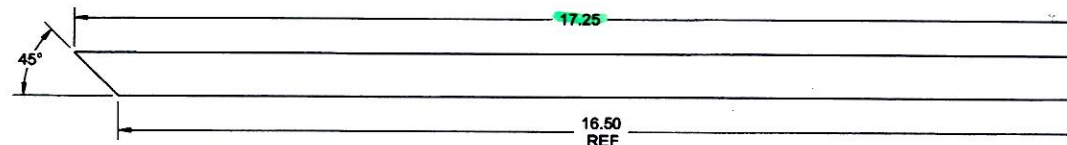
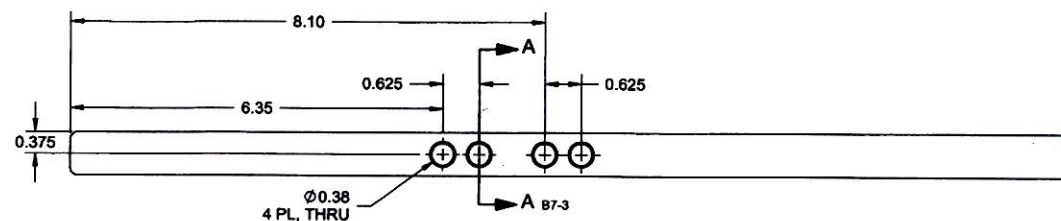




D4034-1 RIB



SECTION A-A C3-3



D4034-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO. D4034	REV. C
MFG. APPR.	AS	TITLE	SHEET 3 OF 3
APPROVED	AP	SCALE	NTS
DE APPR.	AP	UPPER RIB ASSY, BASKET BASE	
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